

What is claimed is:

1. In a roll forming machine of the type which forms an indeterminate length debris shedding rain gutter of a desired lateral profile from a uniform width supply strip of sheet metal having a pair of parallel straight edges, said roll forming machine defining a predetermined path of travel for said supply strip through a plurality of roll forming stations, wherein the desired lateral profile includes a lower trough and an upper hood, with the lower trough including a back wall and a front wall joined to a bottom wall, an arrangement for selectively providing independent adjustment of said profile at at least one predetermined one of said plurality of roll forming stations, the arrangement comprising:

15 a pair of kick forming rollers mounted to a bracket at the entry to a first selected roll forming station and adapted to provide an inward bend near the upper end of the front wall so that the upper edge of the front wall is behind the forward end of the hood, wherein the bracket is independently adjustably mounted to the roll forming machine; and

20 a block adjustably mounted to the roll forming machine at a second selected roll forming station where there is a first roller in contact with the exterior of the back wall of the trough and a second roller in contact with the exterior of the bottom wall of the trough, wherein the block slidably engages the front wall of the trough to form a substantially right angle where the front wall joins the bottom wall, and wherein the block is independently adjustable toward and away from the first and roller.

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2. The arrangement according to Claim 1, wherein the pair of kick forming rollers is arranged to provide a bend of about twenty degrees.

5        3. The arrangement according to Claim 1, wherein the bracket includes a pair of vertically oriented elongated mounting slots so that the position of the inward bend on the front wall is selectively adjustable.

10        4. The arrangement according to Claim 1, wherein:  
the roll forming machine includes a horizontal bracket extending across the second selected roll forming station;  
the horizontal bracket is formed with three through-bores arranged along a straight line and with the center through-bore  
15 being internally threaded;  
the block is mounted to the horizontal bracket by two threaded bolts extending through respective ones of the two outer through-bores and into the block; and  
adjustment of the block is provided by a third threaded  
20 member threadedly engaging the center through-bore and having an end engaging an upper surface of the block.